

Date: Tuesday, 4/18/2006 10:00:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM		
Job Number	: 26663					
Estimate Number	: 10707					
P.O. Number	: N/A		Part Number	: D2012105		
This Issue	: 4/18/2006	S.O. No. : N/A	Drawing Number	: D2012 REV D1		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A	Type : SMALL /MED FAB	Drawing Revision	: D1		
Previous Run	: 24984		Material	: N/A		
Written By	: See JAF COMMENT Below		Due Date	: 5/7/2006 Qty: 5 Um: Each		
Checked & Approved By	: JAF 06.04.18					
Comment	: Est Rev: 02.04.03 Added Inspect level 3 NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 2.7567 f(s)/Unit Total : 13.7834 f(s)

Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Identify as D2012-101

Batch: 019488

FF 06.05.00

5

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch to length as per Dwg D2012-105 & template D2012-105T1

FF 06.05.10

5

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

MF. 06.05.15

5

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-05-25 (5)

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:00:59 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 26663

Part Number: D2012105

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1 06/05/25 (5)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST206

1 06/05/25 (5)
1 06/05/25 (5)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1 06/05/26 (5)

Job Completion



1 06/05/26
W06.05.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

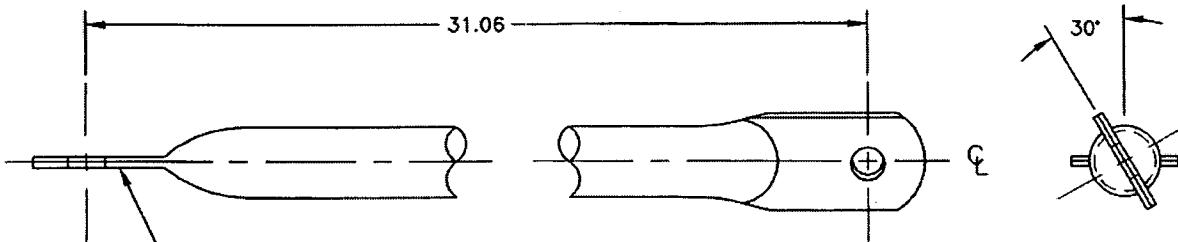
DART**RELEASED**

R

98/05/05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. D	SHEET 1 OF 1
M	J	D2012-105		
DATE		TITLE	SCALE	
98.04.28		ARM	NTS	

A	92.06.04	NEW ISSUE - DRAWN FROM D2012		
B	96.06.25	30° ANGLE ROTATED 60° CCW		
C	97.09.03	CORRECTED VIEWS PER TSR A374		
D	98.04.28	ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD		
D1	92.03.25	ADD FINISH		



NOTES:
 1. MAKE PER TEMPLATE DT8116 (WAS D2012-105)
 2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.500 x 0.035 WALL
 3 FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3 DA

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 26663